

Work Order ID 84841

May-24-12 7:57:57 AM

84841

Page 1

Item ID: D2724-041
Revision ID:
Item Name: 206L Step Assembly

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 24/05/2012 Start Qty: 2.00 ***2***

Required Date: 07/06/2012 Req'd Qty: 2.00 ***2***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/20

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2724	Rev C								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Cut D2724-1 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding								
110		0.00							
110	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig DT (One End Only) A/R AL ROD Batch: <u>120354</u> Grind end cap welds flush <u>120130</u>								

2 ϕ ~~AE~~ Ae
12.07.05

2 ϕ Ae
12.07.05
Ae
12.07.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

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Start Date: 24/05/2012 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 07/06/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150	QC7					2	0	127-12	
QC	Memo	0.00							
Quality Control									
160		0.00							
160	Large Fab					2	0	12.07.13	
Large Fab	Memo	0.00							
Large Fab	Inspect for foreign object per QSI 024								
	Weld Remaining end cap as per Dwg D2724 using Jig DT8884 followed by								
	Jig								
	DT								
	A/R AL ROD Batch: <u>120854</u>								
	Grind per dwg D2724								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									

15 12/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Chemical Conversion Coat per QSI005 4.1

0.00

190

HandFinish

Memo

0.00

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30

320 °F

10:00

2X

LH

M/L
12/07/17

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop *NS2*

Cust Item ID:

Start Date: 24/05/2012 **Start Qty:** 2.00

2

Customer:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

**Insp.
Stamp**

0.00

210

QC

Memo

0.00

Quality Control

Wing Walk as per dwg QSI005 4.4 Batch 11/2/50 5 0.00

220

HandFinish

Memo

0.00

Hand Finishing

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 24/05/2012 Start Qty: 2.00

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Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00

240

Packaging

Memo

PM 84841 0.00

12/7/19

250

QC21- Final Inspection - Work Order Release

0.00

250

QC

Memo

0.00

Quality Control

12/7/20

MR

12-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 1

Work Order ID: 84841

84841

Parent Item: D2724-041

D2724-041

Parent Item Name: 206L Step Assembly

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

100

Each

30.6100

1

2

D2622-120C

Step Extrusion

**

B83894 (2) Cle 12.07.05

Location

Loc Qty

Loc Code

HALL

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA

4.88

81507

4.88

WA013

9.36

75781

2

77612

7.36

D2734

Manufactured No

110

Each

51.0000

1

2

D2734

Step End Plate

**

12.07.09

Location

Loc Qty

Loc Code

WA

B84563

51

76985

5

80682

16

83322

30

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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May-24-12 7:58:01 AM

Page 2

Work Order ID: 84841

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Parent Item: D2724-041

D2724-041

Parent Item Name: 206L Step Assembly

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 2.00

Required Qty: 2.00

D3458-1

Manufactured No

110

Each

19.0000

2

4

D3458-1

Step Mounting Plate

**

12.07.09

Location

Loc Qty

Loc Code

WA

16

82117

16

WA002

2

75609

2

WA018

1

63075

1

D3458-3

Manufactured No

110

Each

29.0000

2

4

D3458-3

Step Mounting Plate

**

12.07.09

Location

Loc Qty

Loc Code

WA

24

82116

24

WA002

5

75610

5

D2734

Manufactured No

160

Each

51.0000

1

2

D2734

Step End Plate

**

12.07.09

Location

Loc Qty

Loc Code

WA

51

76985

5

80682

16

83322

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

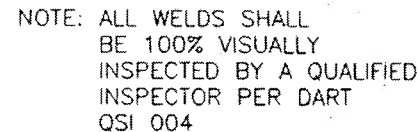
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AER



APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

— REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

SHOP COPY

RETURN TO

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

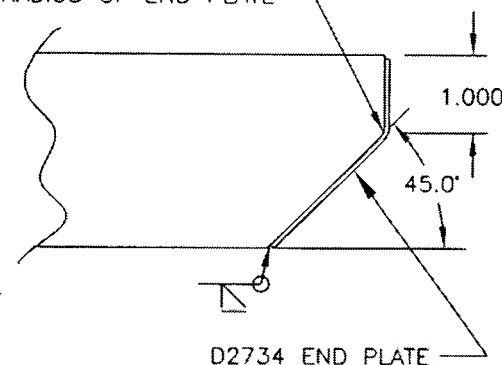
NO. 8484 / 465

TYPICAL STEP END DETAIL

NOT TO SCALE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2734 END PLATE

INTERNET

05-14-4

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2724	REV. C SHEET 1 OF 1
DATE 05.09.19	TITLE 206L/407 STEP ASSEMBLY		SCALE NTS
A	97.12.04	NEW ISSUE	
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C	05.09.19	RE-DESIGN, ADD D3458-1/-3	

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